

Work Order ID 132484

132484

Page 1

Item ID: D3204-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Arm

Stop ***NS2***

Start Date: 5/07/15 Start Qty: 5.00

5

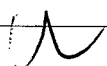
Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3204	Rev A1
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100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

DAS
40
9-89

15/05/22

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.01

HAAS CNC vertical machine #1

1- Machine as per Folio FA344 and Dwg D32042- Deburr/Identify as D3204-3

DAS
40
9-89

15/05/26

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS
40
9-89

15/05/26

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="text-align: center;">Skid-tube ☐</td> <td style="text-align: center;">Cross tube ☐</td> <td style="text-align: center;">Water Jet ☐</td> <td style="text-align: center;">Engineering ☐</td> </tr> <tr> <td style="text-align: center;">Machining ☐</td> <td style="text-align: center;">Small Fab ☐</td> <td style="text-align: center;">Prod. Eng. Coord. ☐</td> <td style="text-align: center;">Quality ☐</td> </tr> <tr> <td style="text-align: center;">Thermoforming ☐</td> <td style="text-align: center;">Finishing ☐</td> <td style="text-align: center;">Rec/Store/Packaging ☐</td> <td style="text-align: center;">Other ☐</td> </tr> <tr> <td style="text-align: center;">Large Fab ☐</td> <td style="text-align: center;">Composite ☐</td> <td style="text-align: center;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :																									

Picklist Print

May-07-15 2:47:02 PM

Page 1
1

Work Order ID: 132484

132484

Parent Item: D3204-3

D3204-3

Parent Item Name: Arm

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.00 0		Purchased	No			100	f	17.8840	0.5538	3			

M6061T6B0 500X02 000

6061-T6 Bar .500 x 2.00

15/05/22

DAS
40
9-89

Location

Loc Qty

Loc Code

MAT001

17.884



124573

4.884

M127464

1

M129375

12

3.0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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OTHER : _____					

DART AEROSPACE LTD		Work Order:	132484
Description: Arm		Part Number:	D3204-3
Inspection Dwg: D3204 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	5.997	✓		H.G.	31002
5.25	+/-0.030	5.247	✓		"	"
0.776	+/-0.010	.773	✓		VGRW	P10-12
Ø0.760	+0.005/-0.000	.760	✓		"	"
0.080	+/-0.010	.076	✓		"	"
R0.50	+/-0.010	.499	✓		Rad G	
2.373	+/-0.010	2.372	✓		VGRW	P10-12
0.750	+/-0.010	.748	✓		"	"
R0.380	+/-0.010	.375	✓		Rad G	
Ø0.375	+0.001/-0.000	.375	✓		PIN G	
0.300	+/-0.010	.298	✓		VGRW	P10-12

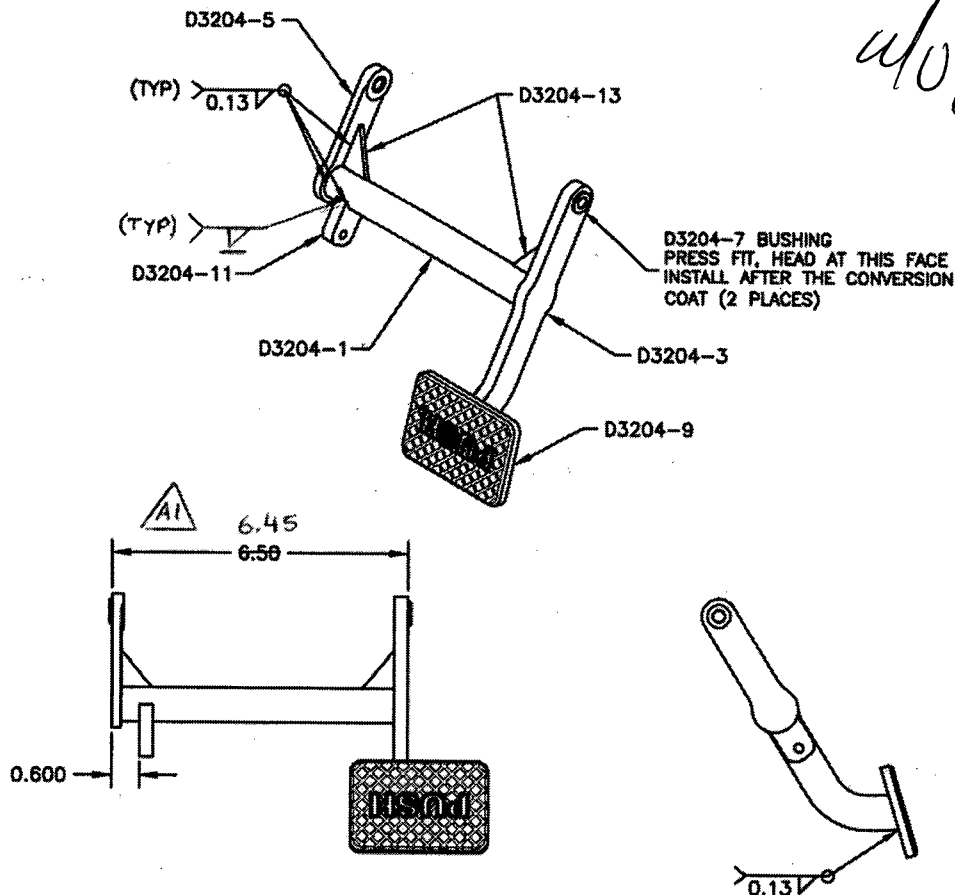
Measured by:	DAS 40 9-09	Audited by:	DAS 08 9-89	Prototype Approval:	N/A
Date:	15/05/26	Date:	15/05/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

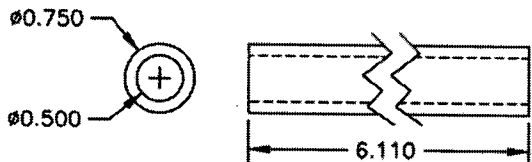
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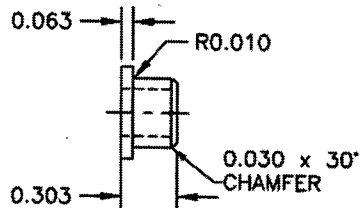


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CHECKED R	APPROVED R	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

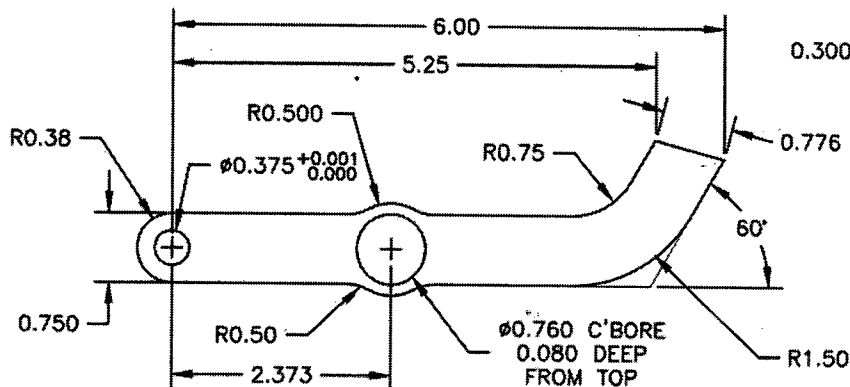
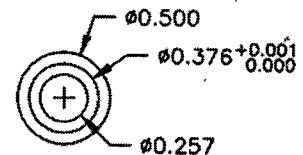
RELEASED
04.04.05



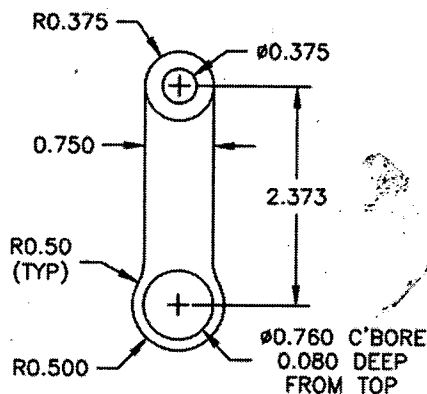
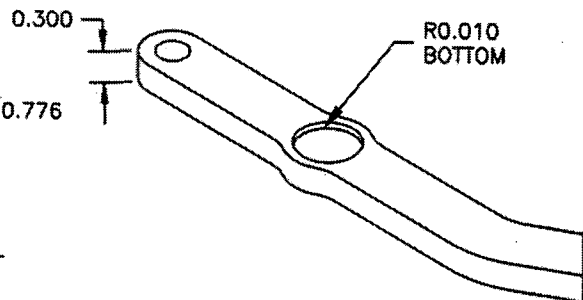
2 D3204-1 TUBE
SCALE 1:2



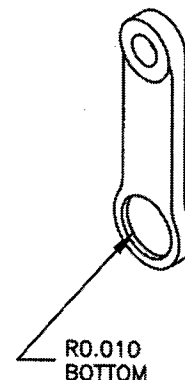
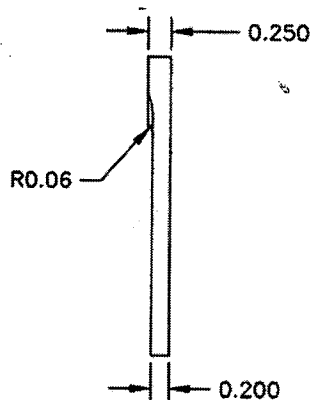
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



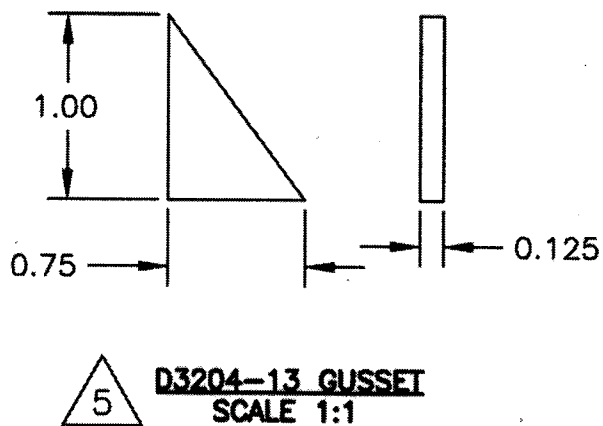
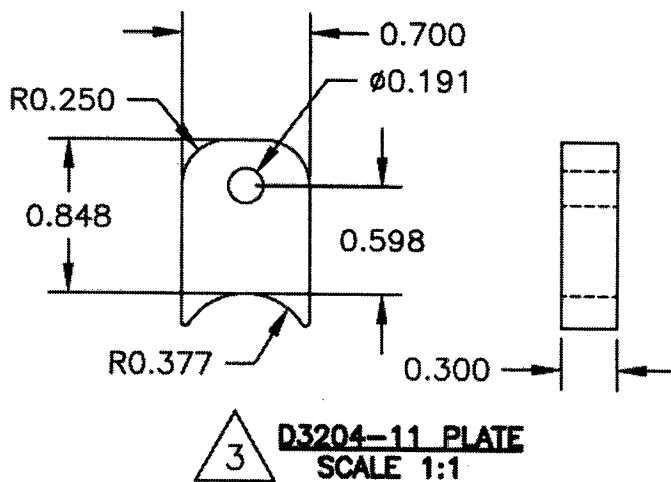
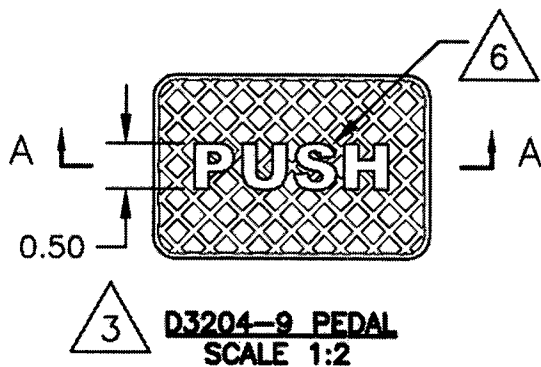
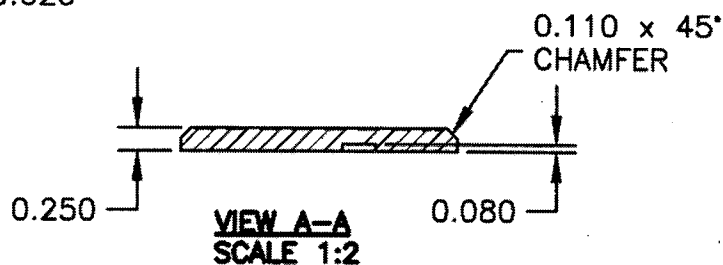
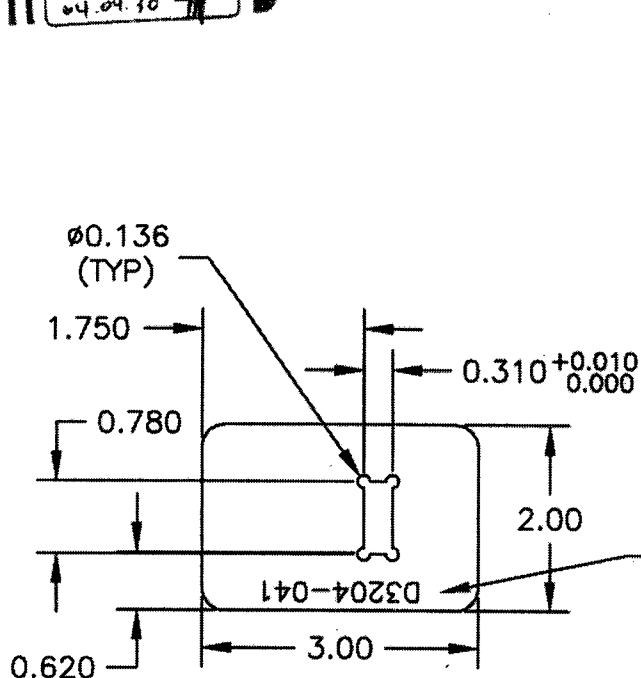
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DESIGN RT	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

RELEASED
04.04.70



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